

Date: Thursday, 6/21/2007 2:29:10 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPLATE	
Job Number	33056		Part Number	D25773	
Estimate Number	10298		Drawing Number	D2577 REV E	
P.O. Number	N/A		Project Number	N/A	
This Issue	6/21/2007	S.O. No.	N/A	Drawing Revision	E
Prsht Rev.	NC	Type	SMALL /MED FAB	Material	N/A
First Issue	N/A		Due Date	7/20/2007	Qty: 30 Um: Each
Previous Run	32097				
Written By					
Checked & Approved By					
Comment	Est: F 02.09.24 Re-format; Incorporated D2577-101/13 K JRF Est. C 06.07.21 waterjet EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		 Comment: Qty.: 0.9240 sf(s)/Unit Total : 27.7200 sf(s) 1010/1025/A21/6aA SHEET 0.063 thick Batch: M104948 <span style="float: right;">07/07/24</span>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut D2577-101 as per Dwg D2577 Dwg Rev: E Prog Rev: E  2-Deburr if necessary <span style="float: right;">SAD 07/07/24 (30)</span>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/07/24 (30)</span>
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK <span style="float: right;">SAD 07/07/24 (30) Cont'd</span>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <span style="float: right;">SAD, 07-07-30</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:11 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33056

Part Number: D25773

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

FF 07-07-31

30

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/01 X3022577-3

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description  
A/R 7560 Hardcoat Rod

Batch  
M105138

ld 07/08/31

30

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/09/04 30

30X

10.0 POWDER COATING POWDER COATING



M1104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m/f 07/09/05

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 07/09/05 30

12.0 PACKAGING 1 PACKAGING RESOURCE #1



30X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

E-P 16

m/f 07/09/06

13.0 QC21 FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

TJ 07/09/06

6 07-09-06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33056
Description: Wearshoe	Part Number:	D2577-3
Inspection Dwg: D2577 Rev: E		Page 1 of 1

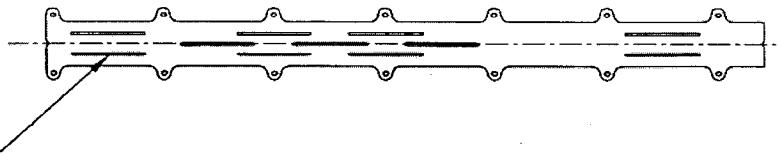
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>Sam</i>	Audited by:	<i>Er</i>	Prototype Approval:	N/A
Date:	<i>07/03/24</i>	Date:	<i>07/07/05</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

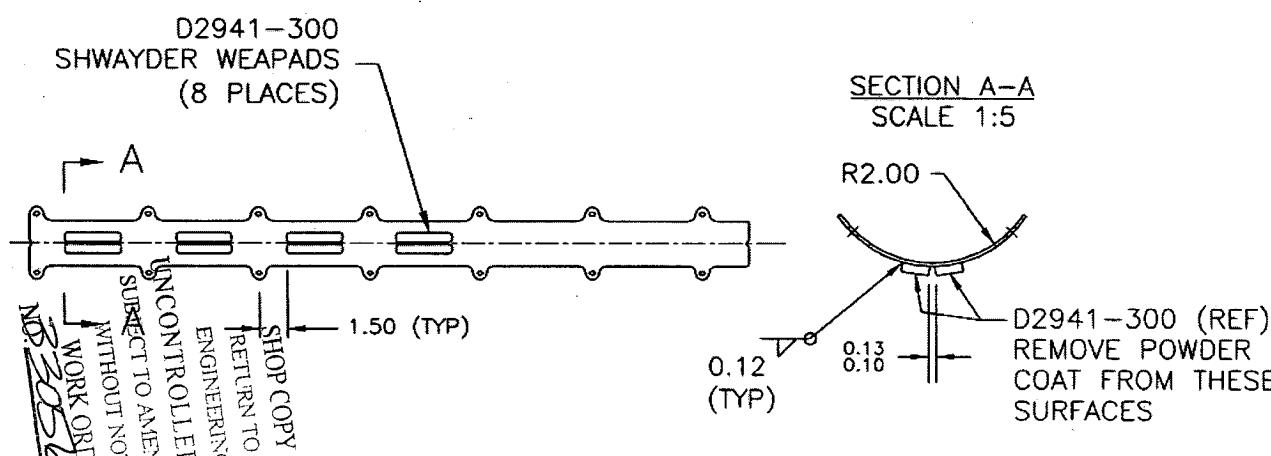
7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

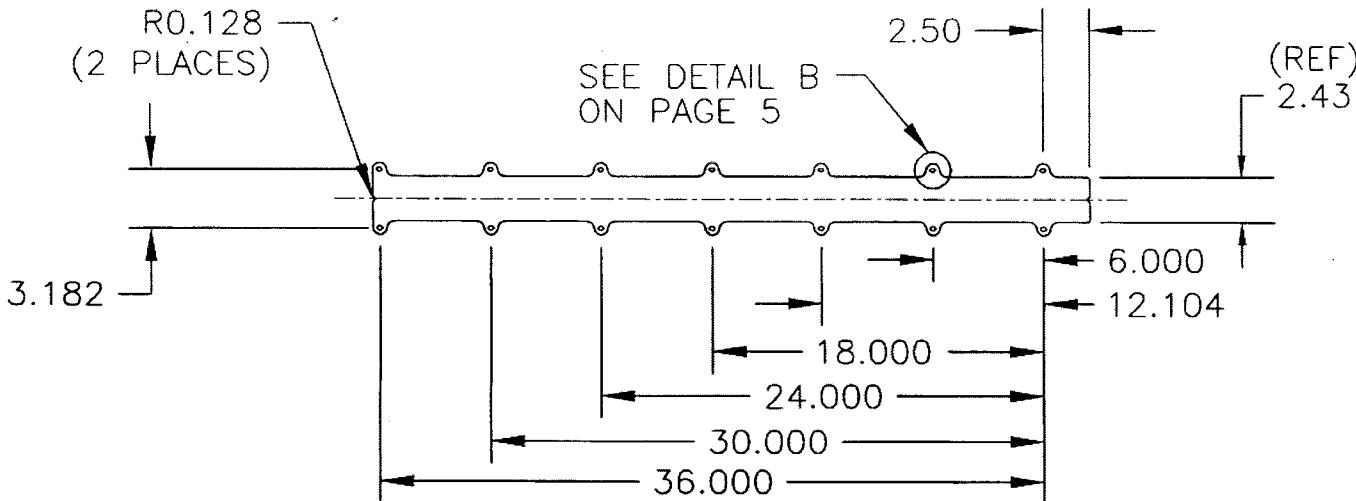
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
*00 04 26 97*

**DART**

*QA/CQ  
GENSE*

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE		TITLE WEARSHOE	SCALE 1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

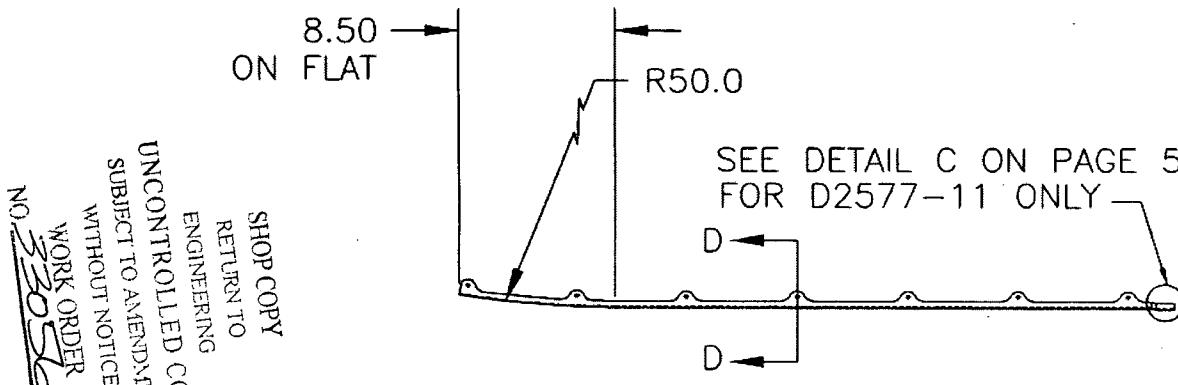


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

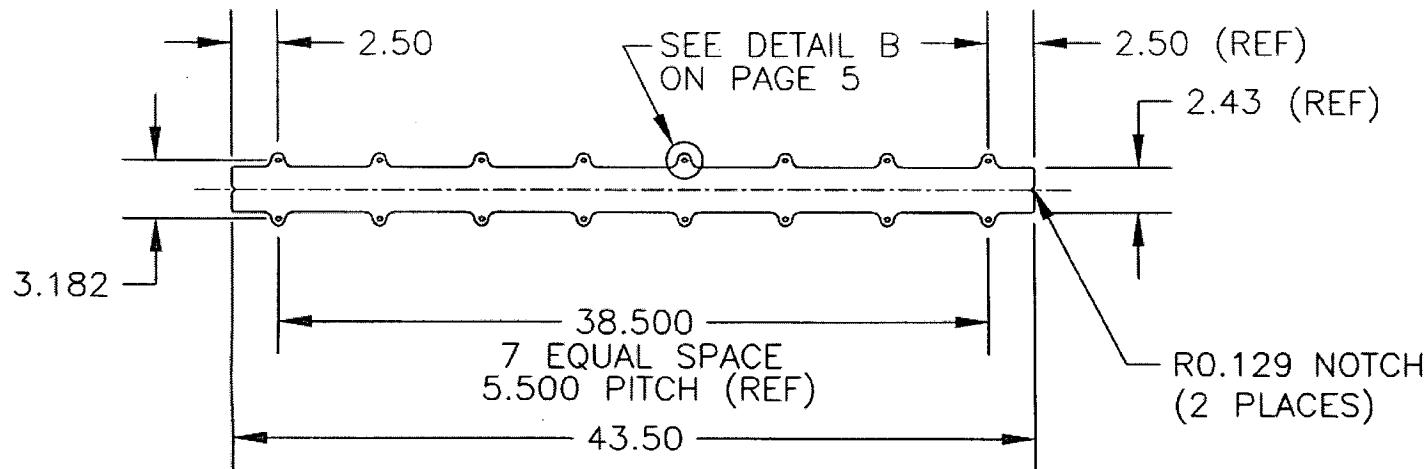
**DART**

COPY  
ISSUE  
0

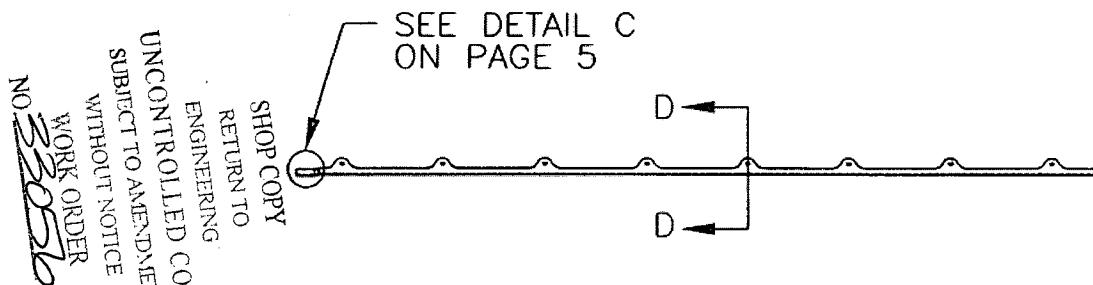
DESIGN <i>df</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>sf</i>	APPROVED <i>sf</i>	DRAWING NO. D2577	REV. E	SHEET 2 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10	

**RELEASED**  
00.09.26 *sf*

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

COPYRIGHT  
DRAFT

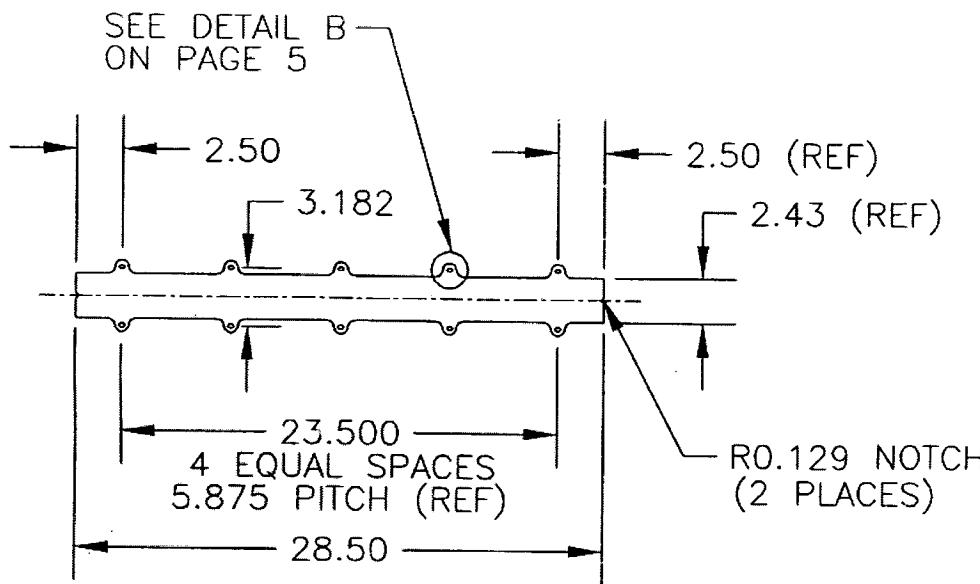
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D2577
DATE	00.09.22	TITLE WEARSHOE
		REV. E
		SHEET 3 OF 5
		SCALE 1:10

**RELEASED**  
09.09.26

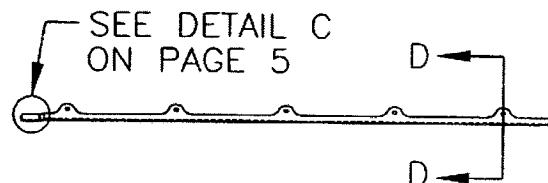
**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2577
DATE 00.09.22	TITLE WEARSHOE	REV. E SHEET 4 OF 5 SCALE 1:10

### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
00.09.26 40

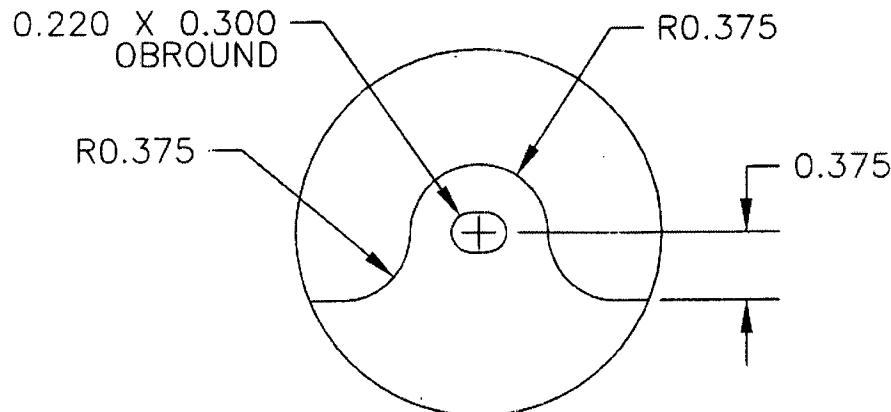
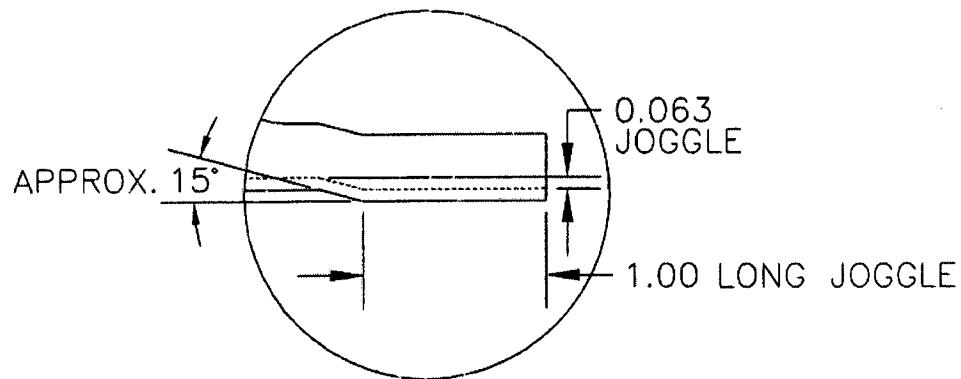
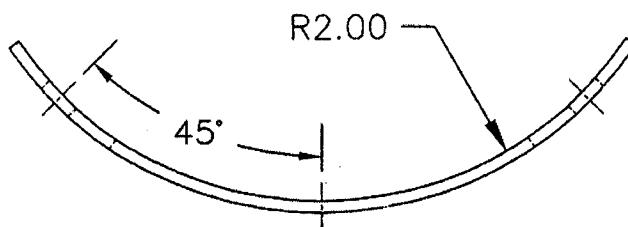
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22056

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1996 by DART AEROSPACE LTD

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**  
00.09.26DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *33056*

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.